

APPLICATION FOR UNITED STATES LETTERS PATENT

DUMMY BAR FOR A CONTINUOUS METAL CASTING PLANT, PARTICULARLY FOR
A CONTINUOUS CASTING PLANT FOR PRELIMINARY STEEL SECTIONS

HM-450

BACKGROUND OF THE INVENTION

1. Field of the Invention

The invention relates to a dummy bar or starter bar for a continuous metal casting plant, particularly for a continuous casting plant for producing preliminary steel sections. The dummy bar includes at least one flexible steel band; the head of the dummy bar is capable of closing the cross section of the mold; and individual segments are connected through the flexible steel band along the length of the steel band up to the end thereof.

2. Description of the Related Art

A dummy bar of the above-described type is disclosed in WO 97/46343. The dummy bar is constructed for the casting of preliminary sections. The dummy bar has a uniform transition portion composed of individual segments which are combined to form a H-shaped cross-section and are attached to the flexible steel band which forms the core of the dummy bar. The transition portion is releasably connected to a standard portion which is also connected to a flexible steel band. However, the H-shaped cross-section is formed of a plurality of cover plates and side plates so that the manufacture is complicated and the dummy bar

Year	1970	1971	1972	1973	1974	1975	1976	1977	1978	1979	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100
1970	1971	1972	1973	1974	1975	1976	1977	1978	1979	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100	

SUMMARY OF THE INVENTION

Therefore, it is the primary object of the present invention to improve the flexibility of such a dummy bar, so that a dummy bar with a lower weight is achieved which requires reduced force application for the transport and manipulation thereof.

In accordance with the present invention, the above object is met by providing the beginning of the dummy bar for the cross-section of the mold with a one-piece head piece which in its dimensions corresponds to those of the cross-section of the mold, wherein two parallel rows of segments are connected to the head piece, wherein the two rows are spaced apart from each other by the width of the strand and the rows extend in the longitudinal direction of the strand, and wherein the segments of each row are connected to each other through a flexible steel band which is mounted on the segments and ensures that the rows of segments are bendable along curves.

As a result of the configuration of the present invention, the steel band provides a better flexibility or articulation because the steel band is located on the inner side of curved portions and on the outer side of the row of segments. This reduces the bending work which has to be performed. Another

advantage is the fact that the segments can be guided without play. In addition, there is the advantage that in continuous casting plants for preliminary sections the cross-section of the two rows of segments can follow and simply form a continuation of the cast section.

The restoring force when bending the steel strip and the capability of absorbing bending forces can be further improved if the flexible steel band is constructed as a spring steel band.

In accordance with a further development of the invention, the head piece has at least one recess extending transversely of the longitudinal direction of the dummy bar for connecting the dummy bar to the hot strand. This makes it unnecessary to use conventional tongue-shaped elements for disconnecting.

In accordance with other features, cross-connecting elements are provided between the two rows of segments and spaced apart from each other in the longitudinal direction of the dummy bar, wherein the cross-connecting elements are attached to two oppositely located segments. The advantage of this configuration is a parallel guidance of the two rows of segments and stiffening of the entire dummy bar without significantly increasing the weight of the dummy bar.

In accordance with another advantageous feature, the segments following the head piece in the longitudinal direction of the dummy bar are constructed as transition segments having a reduced thickness. As a result, a weight reduction of the segments is achieved beginning with the first segment following the head piece so that the following segments have a smaller thickness and, thus, a lower weight.

In accordance with another development, the segments of a row of segments are connected to each other in an articulated and pivotable manner by means of keys and slots. The bending movement of the segments relative to each other advantageously takes place in a vertical plane so that a lateral guidance is effective at the same time.

In accordance with a further development, the individual segments are bevelled so as to downwardly recede at the oppositely located surfaces of the two rows. Consequently, the dummy bar can be guided on the lower side thereof and/or at the cross-connecting elements.

In accordance with another advantageous feature, the head piece and/or the individual segments are provided with inner hollow spaces to reduce the weight. The weight reduction is very

significant in dependence on the number of segments without leading to a weakening of the dummy bar.

In accordance with another proposed feature, the spring steel bands are screwed or riveted to each row of segments. This simplifies the assembly.

Finally, the dummy bar can be used in an advantageous manner if the two rows of segments with spring steel bands mounted thereon are spaced apart from each other in accordance with the width of a H-section of the hot strand.

The various features of novelty which characterize the invention are pointed out with particularity in the claims annexed to and forming a part of the disclosure. For a better understanding of the invention, its operating advantages, specific objects attained by its use, reference should be had to the drawing and descriptive matter in which there are illustrated and described preferred embodiments of the invention.

The single Figure of the drawing is a perspective view of a dummy bar for the continuous casting mold area of a continuous casting plant.

Year	1970	1971	1972	1973	1974	1975	1976	1977	1978	1979	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100
1970	1971	1972	1973	1974	1975	1976	1977	1978	1979	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100	

DESCRIPTION OF THE PREFERRED EMBODIMENTS

The dummy bar illustrated in the drawing is used for a continuous metal casting plant, particularly a continuous casting plant for producing preliminary steel sections. However, the dummy bar can also be used for slab strands, block strands, or the like.

The individual segments 1 are connected to each other by means of a flexible steel band 2 in the form of a spring steel band 2a. The head 3 consists of a one-piece head piece 3a which closes off the mold cross-section or casting cross-section. The spring steel band 2a starts at least at the segments 1a which have a reduced thickness. The segments 1 located between the head piece 3a and the segments 1a having a reduced thickness can also be connected to each other in an articulated manner through bolts 4. In the illustrated embodiment, the spring steel band 2a begins at the segments 1a having a reduced thickness.

Connected to the beginning 5 for the mold cross-section 6 are two rows 8a and 8b of segments 1 which extend parallel to each other in the longitudinal direction 9 of the dummy bar. These segments 1 can bend along curved portions and are connected within each row 8a and 8b by flexible steel bands 2 mounted on

the segments 1. The flexible steel band 2 is constructed as a spring steel band 2a. Provided in the one-piece head piece 3a is at least one recess 10 extending transversely of the longitudinal direction 9 of the dummy bar for effecting the connection to the hot strand. Cross-connecting elements 11 are provided between the two rows 8a and 8b of segments 1, wherein the cross-connecting elements 11 are arranged spaced apart from each other in the longitudinal direction 9 and are connected to segments 1 of each row located opposite each other. The segments 1a following the head piece 3a in the longitudinal direction 9 are constructed with decreasing thickness. In order to be able to carry out a curved movement within a vertical plane, the segments 1 of each of the rows 8a or 8b are connected to each other in an articulated manner by means of keys 13 and slots 14.

The individual segments 1 are bevelled so as to recede downwardly at opposite surfaces 15 of the two rows 8a and 8b.

For weight reduction, the head piece 3a and/or the individual segments 1 are provided with hollow spaces 16.

The spring steel bands 2a are screwed or riveted to the respective rows 8a and 8b of segments 1.

To provide for the special case of casting preliminary strands, such as I-strands or H-section strands, the two rows 8a and 8b of segments 1 with spring steel bands 2a mounted thereon are spaced apart from each other in accordance with the width of a I-shape or H-shape of the hot strand.

While specific embodiments of the invention have been shown and described in detail to illustrate the inventive principles, it will be understood that the invention may be embodied otherwise without departing from such principles.